

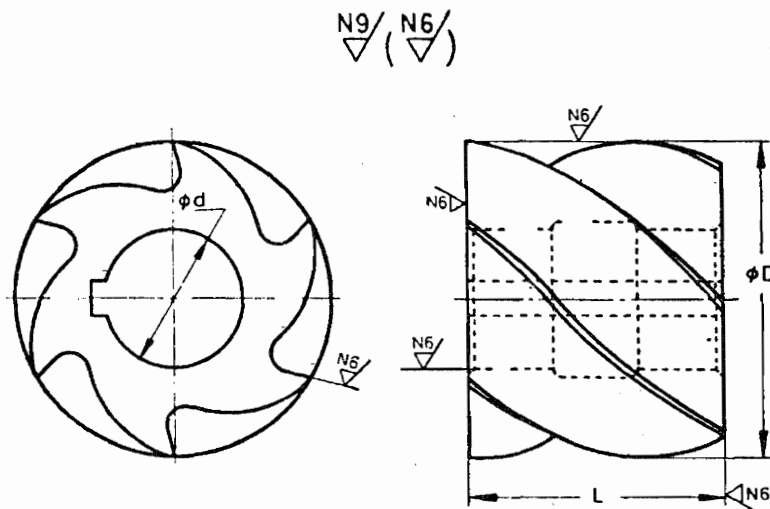
Indian Standard  
SPECIFICATION FOR  
CYLINDRICAL MILLING CUTTERS  
(First Revision)

(Reaffirmed 2013)

**1. Scope** — Covers the dimensions and requirements for solid and interlocking cylindrical milling cutters with plain bore and key drive.

**2. Dimensions**

**2.1 Solid Cylindrical Milling Cutter**



All dimensions in millimetres

D js16	d H7	L js16	Tool-Type
50	22	40	N, H, S
63	27	50	
80	32	63	
100	40	70	
		100	
		125	

Note — The figure is indicative of dimensions only and does not specify design features.

Adopted 27 July 1982

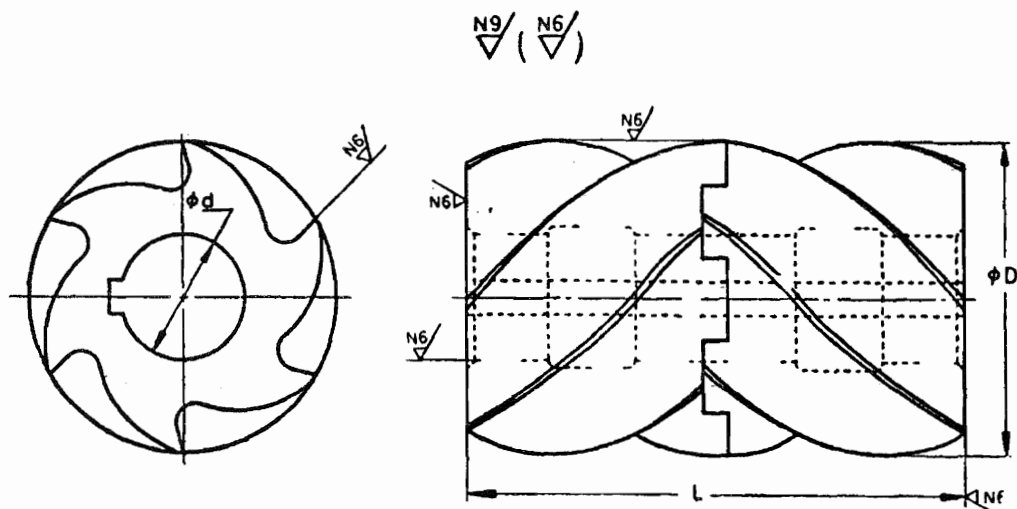
© December 1982, BIS

Gr 2

BUREAU OF INDIAN STANDARDS  
MANAK BHAVAN, 9 BAHADUR SHAH ZAFAR MARG  
NEW DELHI 110002

MAX. RETAIL PRICE  
INCL. OF ALL TAXES  
\$130..

## 2.2 Interlocking Cylindrical Milling Cutter



All dimensions in millimetres

D js16	d H7	L js16	Tool-Type
80	32	80	N, H, S
		125	
100	40	100	
		160	
125	50	125	
		200	
160	60	160	
		250	

**Note —** The figure is indicative of dimensions only and does not specify design features.

## 3. General Requirements

3.1 Unless otherwise specified the cutters shall be of solid type with RH helicoidal teeth angled to the left and right alternately.

3.2 Dimensions of keyways shall be according to IS : 6285-1971 'Dimensions for interchangeability of milling cutters and milling arbors with key drive'.

3.3 For requirements not covered in this standard, it shall conform to the requirements as given in IS : 1830-1982 'Technical supply conditions for milling cutters (second revision)'.

4. Sampling — The sampling and criteria of acceptance shall be in accordance with IS : 7778-1975 'Methods for sampling small tools'.

## 5. Designation

5.1 A solid cylindrical milling cutter having diameter  $D = 80$  mm, length  $L = 100$  mm of tool type N, made from high speed steel and conforming to this standard, shall be designated as:

Solid Cylindrical Milling Cutter 80 × 100 IS:6309

**5.1.1** When the solid cylindrical milling cutter is required with tool-type other than N, the tool type H or S, as appropriate, shall be added immediately after the size.

*Example :*

A solid cylindrical milling cutter, having  $D = 80$  mm, length  $L = 100$  mm of tool type 'H', made from high speed steel and conforming to this standard shall be designated as:

**Solid Cylindrical Milling Cutter 80×100 H IS : 6309**

**5.2** An interlocking cylindrical milling cutter having diameter  $D = 100$  mm, length  $L = 160$  mm of tool type 'N' made from high speed steel and conforming to this standard, shall be designated as:

**Interlocking Cylindrical Milling Cutter 100×160 IS : 6309**

**5.2.1** When the interlocking cylindrical milling cutter is required with tool-type other than N, the tool type H or S, as appropriate shall be added immediately after the size.

*Example:*

An interlocking cylindrical milling cutter having  $D = 100$  mm, length  $L = 160$  mm, of tool type 'H', made from high speed steel and conforming to this standard, shall be designated as:

**Interlocking Cylindrical Milling Cutter 100 × 160 H IS : 6309**

**6. Certification Marking** — Details available with the Bureau of Indian Standards.

## EXPLANATORY NOTE

This standard was first published in 1971. This revision is necessitated so as to bring it in line with the work done at ISO level.

In the preparation of this standard considerable assistance has been derived from:

ISO 2584-1972 'Cylindrical cutters with plain bore and key drive-Metric Series'. International Organization for Standardization.

DIN 884-1976 'Walzenfraser' (Solid cylindrical cutters). Deutsches Institut für Normung.

**AMENDMENT NO. 1 OCTOBER 1996  
TO  
IS 6309 : 1982 SPECIFICATION FOR  
CYLINDRICAL MILLING CUTTERS**

*( First Revision )*

*( Page 2, clause 3.1 )* — Substitute the following for the existing:

'3.1 Unless otherwise specified the cutters shall be solid type with right hand helicoidal teeth.'

( PE 11 )

---

Reprography Unit, BIS, New Delhi, India